Work Ordon				*107	7422*						Page 1
Item ID: Revision ID: Item Name:	D2369-3 Locator Plate			Accept	*N900	040	100)* s	Setup Sta	I A	S1* S2*
Start Date: Required Date: Reference:	9/23/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					
Approvals:	Process Pla	n·	Date:	Tooling:	D:	ate:	_	F	Run Sta	rt *N	R1*
Approvais.	QC:		Date:	SPC (Y/N):		ate:			Sto	^{op} *N	R2*
Sequence ID/ Work Center I	D	Operation Description	16	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		ision Nbr	, <u> </u>								
100		FLOW WATER JET		0.00							7 -
100 Waterjet FLOW CNC Water	int	Memo	r Dwg D2369	0.00				~	0	<u></u>	JMB-09-2
5063 (4 0,	Dwg Rev:_	<u>a</u>	,					-	•	
6061 ·04	10.	Prog Rev 2-Deburr if	necessary								

Jm13-09-29

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

110

*11**0***

Quality Control

NCR: Y	es / No				WORK ORDER NON-C	100	NFOR	MANCE / UPI	DATE	•		
										QA Closed:	Date:	·
Work Orde	er:				DISPOSITION	,			AGAINST DE	PARTMENT,	,	
Part N	lo				Rework Scrap Use-as-is		١	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update			Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	Ī	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data					,							
Equip/Tooling											•	
Operator												
Material												
Setup												
Other				1								
Process												
Supplier				i								
Training												
Unapproved												
					F/	AUL	T CATE	GORY				
Landir	ng Gear				General	_			٠	•	_	
	Bending				Bend	<u> </u>	Grain			Ovalized	·	Pressure/Forced
	Centre No	ot,Concei	ntric to (o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
]	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorred	ct .	Weld
	Crushed/	Crimped		L	Burrs	L	Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
·	Cuffs			L	Contamination		Mainte	nance		Part Moved		•
	Heat Trea	ət			Countersink		Mislabe	led		Positioned V	Vrong	•
	Inspectio	n _. Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other -
	Ripples in	n Bend			Drill Holes		Offset					
	Torque W	Vaves in E	Extrusio	n [Drawing		Out of 0	Calibration				
	Turning S	equence			Finish		Out of S	Sequence				
	Wave/Tw	vist in Tul	эе	. [Folio		Outside	Dimensions				

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord September-23-				*1(77422*		
Item ID: Revision ID:	D2369-3			Accept	*N900040100*	Setup	
Item Name:	Locator Plat	e					Stop
Start Date:	9/23/13	Start Qty: 4.00	*4*		Cust Item ID:		
Required Dat	te: 9/23/13	Req'd Qty: 4.00	*4*		Customer:		
Reference:			•			D	Start
Approvals:	Process P	lan:	Date:	Tooling:	Date:	Run	Start
Appi ovais.	1 1 0 0 0 3 1	101111					Stop

Reject Reject Insp. Tool ID Tool # Plan Accept Set Up/ Operation Sequence ID/ Number Stamp Code Qty Qty Run Hours Description Work Center ID 0.00QC8- Inspect parts - second check 120 DAS 27 *120* 0.00 Memo Quality Control

Date:

SPC (Y/N):

Identify as per dwg & Stock Location: 57-24 A-0.00 150 *150* Packaging

QC: ____

Packaging

0.00 Memo

Date:____

Page 2

QC21- Final Inspection - Work Order Release 0.00 160 *160*

0.00 Memo

Quality Control

NCR:	⁄es	/ No				WORK ORDER NON-C	COI	NFORM	MANCE / UPI	DATE			•
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	٠ ١٥٠					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Π	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material		· 											
Setup						,							
Other													
Process										,			
Supplier													
Training													
Unapproved													
,							AUL	LT CATE	GORY				
Landi	Ť	1				General	_	7			a	,	٦
	-	Bending			_	Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
1	_	Centre No	ot Conce	ntric to	o/s	BOM/Route	_	Hardwa			Over/Under	<u> </u>	Temperature/Cure
	\vdash	Cracks				Broken/Damaged	_	- '	on Incomplete		Part Incorred		Weld
	-	Crushed/	Crimped			Burrs		-	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs	•			Contamination	\perp	Mainte		<u> </u>	Part Moved		
,	-	Heat Trea				Countersink	_	Mislabe		<u></u>	Positioned W		. ·
	_	Inspectio		Tube	<u> </u>	Cut Too Short	_	Misread	i		Power Loss/S	Surge	Other
	_	Ripples in			<u> </u>	Drill Holes		Offset					
,	L	Torque W			n	Drawing	L	4	Calibration				·
1		Turning S	equence		1	Finish		Out of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

September-23-13 11:50:44 AM

Work Order ID:

107422

Parent Item:

D2369-3

Parent Item Name:

Locator Plate

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev A IPP Rev:B

Removed from 9 Digit 05-12-05 JLM

Now on Waterjet 07-05-28 JLM

IPP REV:C 13.05.21 AS PER

DWG REV.B VERF:JLM

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
_	M5052H32S 040 5052-H32 .040 Sheet		Purchased	No			110	sf	212.2600	1.354	_ .5.70105 .	28	13+0	9.28
		~			Location		Loc Qty	<u>Lo</u>	c Code					
					MAT022		212.260045							
					122	406	14.160045							
					124	445	7							,
					124	573	39.1							
					125	552	24				<u> 5552</u>			
					m1	26593	128							

MGOG1765.040"

126350

126350 6 S.F. Jm1309-29

NCR:	⁄es	/ No				WORK ORDER NON-O	100	NFORI	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	er:				***************************************	DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS	
Part N	-					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Rec/Stor	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update		Initial		tion	Sign &		
Cause		Date ^	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling											, .		
Operator	Ш											·	
Material	H												
Setup	\square]									
Other	Ш			Ì		•							
Process	\square				ł I					•		•	
Supplier	Щ												
Training	Щ						1						
Unapproved			<u>l </u>	<u> </u>	<u> </u>								
						· ····································	AUL	T CATE	GORY				£*.
Landi		1				General		1		_	7		1
	ш	Bending			<u> </u>	Bend	-	Grain			Ovalized	⊢	Pressure/Forced
,	_	Centre No	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa		·	Over/Under	_	Temperature/Cure
	\vdash	Cracks				Broken/Damaged	\vdash	4	on Incomplete		Part Incorred		Weld
	_	Crushed/	Crimped		_	Burrs	-	1	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	-	Cuffs			<u> </u>	Contamination	\vdash	Mainte		<u> </u>	Part Moved		
	\vdash	Heat Trea			<u> </u>	Countersink	-	Mislabe			Positioned V		املات
.	-	Inspectio		Tube	<u> </u>	Cut Too Short	\vdash	Misread	1	L.	Power Loss/	Surge	Other
	-	Ripples in			<u> </u>	Drill Holes	\vdash	Offset	na Pilo a sakta a				
	\vdash	Torque W			n	Drawing	-	4	Calibration				
l	1	Turning S	equence	!	1	Finish		¡Out of \$	Sequence				

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order:	10441
Description: Deck Plate Locator Bracket	Part Number:	D2369-3
Inspection Dwg: D2369 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.504"			V	Jamo1
4.500	+/-0.010	4.501	-		V	
5.649	+/-0.010	5651"	_		V	
Ø0.128	+0.005/-0.000	0.130	-		V	
37.990	+/-0.010	37.990			<u> </u>	Jemois
38.297	+/-0.010	38.297	-		T	
5.000	+/-0.010	5.003			V	
4.490	+/-0.010	4.490"	_		V	
0.664	+/-0.010	0.667	_		V	
39.000	+/-0.010	39.0004	-		T	
38.528	+/-0.010	38.538"	_		7	
0.940	+/-0.010	0.946	-		V .	
		·				
					,	
			DAS			

			<u> </u>		
Measured by:	TM	Audited by:	9-89	Preliminary Approval:	
Date:	1309-29	Date:	13 9 30	Date:	

Rev	Date	Change		1	Revised b	y_	Approved
Α	04.06.25	New Issue	P/O D350-616-015	,	KJ/JLM	Δ	
В	13.06.26	Dimensions up	dated per Dwg Rev B		KJ q	<u>Y</u> _	
	10.00.20	T Difficiliations up	dated per bwg nev b		+	71	1-1-1-

